

Oct 26

U/R

ok 9/16/17

Work Order ID 148123

148123

Page 1

Friday, June 24, 2016 2:05:37 PM

Item ID: D119-646-041

Accept

N900040100

Setup Start *NS1*

Revision ID: URF 15-560

Stop *NS2*

Item Name: Replacement Skidtube with Wearpads, Fits LH or RH

Start Date: 9/1/2016 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 9/23/2016 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: 2m Date: 16/06/24 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3887-041	D								
IIN-D119-646	C								

100

0.00

100

DC

Doc.Control -USB or Paperwork

Memo

0.00

Photocopy bluefile & type labels per PPP D119-646-041 CHG004

N/A

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

- 1- inspect Mat'L D2500-1-190 for damage
- 2-Cut tube to length as per dwg D3887 (154.8")
- 3- Ensure squareness of ends and scribe batch#

16-9-7 N.G

DAS
19
9-09

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Work Order ID 148123

148123

Page 2

Friday, June 24, 2016 2:05:37 PM

Item ID: D119-646-041 **Accept** ***N900040100*** **Setup Start** ***NS1***
Revision ID: URF 15-560 **Stop** ***NS2***
Item Name: Replacement Skidtube with Wearpads, Fits LH or RH
Start Date: 9/1/2016 **Start Qty:** 1.00 ***1*** **Cust Item ID:**
Required Date: 9/23/2016 **Req'd Qty:** 1.00 ***1*** **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** ***NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Chemical Conversion Coat per QSI005 4.1	0.00				(x1)	Ø		2016/09/09
120									BET
HandFinish	Memo	0.00							
Hand Finishing									
121	QC7-Inspect Chemical Conversion Coat	0.00				1	Ø		16-09-14
121									
QC	Memo	0.00							
Quality Control									
122	QC5- Inspect part completeness to step on W/O	0.00				1	Ø		16-09-14
122									
QC	Memo	0.00							
Quality Control									

DAS
18
9-89

DAS
18
9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
3-2-01 8-1 02-01				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 148123***148123***

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Friday, June 24, 2016 2:05:37 PM

Item ID: D119-646-041

Accept

N900040100

Setup Start

NS1

Revision ID: URF 15-560

Stop

NS2

Item Name: Replacement Skidtube with Wearpads, Fits LH or RH

Start Date: 9/1/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/23/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Skidtubes	Memo	0.00							
Skidtubes	1- Install drill Jig DT9477 drill X-bolt spacer pilot holes using 3/16" drill first side only.								
	2- 2nd side, locating from first saddle holes use DT9861 A/B to drill 2nd side fwd saddle holes.								
	3- 2nd side locating from fwd saddle drill remaining crossbolt spacer holes usin DT9477								
	4- Open crossbolt spacer holes to finished size as per dwg D3887 (section D-D and E-E) ***DO NOT OPEN FWD Saddles Holes***								
	5- Deburr, blow out chips from inside of tube.								
	6- Bond web in place as per Dwg D3887 & QSI 015. A/RSikaflex-291 <u>135376</u> Sikaflex expire date: <u>17-2-16</u> Start: _____ Time: _____ Finish: _____ Time: <u>9:00</u> ***** (Adhere for 12 hours) *****								

16-9-19 

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 148123***148123***

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Friday, June 24, 2016 2:05:37 PM

Item ID: D119-646-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 15-560 Stop ***NS2***
Item Name: Replacement Skidtube with Wearpads, Fits LH or RH
Start Date: 9/1/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/23/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
135	QC5- Inspect part completeness to step on W/O	0.00							
135									
QC	Memo	0.00							
Quality Control									

DAS
18
9-20

1 0 16-09-20

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 148123***148123***

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Friday, June 24, 2016 2:05:37 PM

Item ID: D119-646-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 15-560 Stop ***NS2***
Item Name: Replacement Skidtube with Wearpads, Fits LH or RH
Start Date: 9/1/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/23/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00

140

Skidtubes

Skidtubes

Memo

0.00

1- Bend FWD end of tube using bender 1 and FOLIO 31 bend prog.
D3887.***Must use bending aid DT9544, ensure proper positioning***

2- Cut FWD end of tube as per dwg D3887.***Verify measurment***

3- Buff out marks left from bending

4- Drill FWD cap holes using DT8215. Open FWD & AFT cap holes to 0.208"

5- Open FWD saddle holes to finished size as per dwg D3887

6- Drill FWD x-bolt spacer holes using DT9816 and open to finished
size.(verify measurement)

7- Drill Tow ring hole, using DT10047 locate from FWD saddle hole. (verify
neasurement). Open to finished size.

8- Drill 1.87" and 3.74 holes using DT10045 A&B locate from FWD saddle
hole. (verify measurement) as per dwg.

9- C'sink FWD cap hole as per detail "C"

10- Drill holes for wearpads using DT8931, open to 0.297".

11- Countersink crossbolt spacer holes, and prepare tube for welding, deburr.

12- Deburr and blow out chips from inside of tube.

16-9-20 JH/KW

16-9-28 JH

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 148123***148123***

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Friday, June 24, 2016 2:05:37 PM

Item ID: D119-646-041 **Accept** ***N900040100*** **Setup Start *NS1***
Revision ID: URF 15-560 **Stop *NS2***
Item Name: Replacement Skidtube with Wearpads, Fits LH or RH
Start Date: 9/1/2016 **Start Qty:** 1.00 ***1*** **Cust Item ID:**
Required Date: 9/23/2016 **Req'd Qty:** 1.00 ***1*** **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start *NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

DAS
18
9-89

1 8 16-09-29

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER :						

Work Order ID 148123***148123***

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-Friday, June 24, 2016 2:05:37 PM

Item ID: D119-646-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 15-560 Stop ***NS2***
Item Name: Replacement Skidtube with Wearpads, Fits LH or RH
Start Date: 9/1/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/23/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160 Skidtubes	Memo NOTE:TACK IN 2 MOST FWD X-BOLT SPACERS AND TEST FIT FWD GROUND HANDELING FIXTURE,IF FIXTURE FITS WELL THEN PROCEED. FIXTURE DT10091.	0.00							
Skidtubes	1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3887. Remember to back drill each hole before welding the other side. Use aluminum rod A/RAluminum Rod <u>m134826</u>								
	2-Grind cross bolt welds flush as per Dwg D3887. Ensure no pin hole.								
	3-Counterbore 5/16" x 0.750" deep as per Dwg D3887.								
	4- Deburr & Scribe batch # on Aft end of tube.								
170	QC5- Inspect part completeness to step on W/O	0.00							
170 QC	Memo TEST FIT USING FIXTURE DT10091.	0.00							
Quality Control									

7 BE/16-09-29
BE/16-10-20

DAS
38
9-89

OCT 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 148123

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Item ID: D119-646-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 15-560 Stop ***NS2***
Item Name: Replacement Skidtube with Wearpads, Fits LH or RH
Start Date: 9/1/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/23/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				1			DAS 38 OCT 4 2016
190 *190* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.	0.00 0.00							1 d 16/10/16
200 *200* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 8:45 OVEN TEMPERATURE: 320° FINISH TIME: 9:15	0.00 0.00							1 d 16-10-17 DAS 34 389

★
SEE
Attached

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																													
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																																											
Description Work Order Deviation			Disposition																																																																												
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			QC / QA Coordinator Approval																																																																												
<table style="width:100%; border-collapse: collapse;"> <tr> <th colspan="3" style="text-align: left;">Root Cause</th> <th colspan="3" style="text-align: left;">FAULT CATEGORY</th> </tr> <tr> <td style="width:15%;">Environment ☐</td> <td style="width:15%;">No Re-verification ☐</td> <td style="width:15%;">Pressure/Forced ☐</td> <td style="width:15%;">Temperature/Cure ☐</td> <td style="width:15%;">Power Loss/Surge ☐</td> <td style="width:15%;">Positioned Wrong ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td colspan="4" rowspan="2" style="text-align: center; vertical-align: top;">OTHER : _____</td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> </tr> </table>						Root Cause			FAULT CATEGORY			Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				Misidentified ☐	Past Due ☐
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**Friday, June 24, 2016 2:05:37 PM*

Item ID: D119-646-041

Accept

N900040100

Setup Start *NS1*

Revision ID: URF 15-560

Item Name: Replacement Skidtube with Wearpads, Fits LH or RH

Stop *NS2*

Start Date: 9/1/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 9/23/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : ☐							

Work Order ID 148123***148123***

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Friday, June 24, 2016 2:05:37 PM

Item ID: D119-646-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 15-560 Stop ***NS2***
Item Name: Replacement Skidtube with Wearpads, Fits LH or RH
Start Date: 9/1/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/23/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240		0.00							
240		0.00							
HandFinish									
Hand Finishing									
	Memo								
	1-Install wearpads, gaskets as per Dwg D3887. Put sikaflex in insert before installing bolts and washers A/R Sikaflex-240/-291 <u>M135376</u> Sikaflex expire date: <u>16/12</u>								
	2-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>M135473</u>								
	3 -Inspect for foreign objects as per QSI 024								
	4 -Install Aft Cap and seal with Sikaflex. Clean excess adhesive. A/R Sikaflex-240/-291 <u>M135376</u> Sikaflex expire date: <u>16/12</u>								
245	QC5- Inspect part completeness to step on W/O	0.00							
245									
QC									
Quality Control									

SEE Attached

RTU 598 M135426 16/11

DAS 38 00124 ZU10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY								
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							

Work Order ID 148123***148123***

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*Friday, June 24, 2016 2:05:37 PM

Item ID: D119-646-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 15-560 Stop ***NS2***
Item Name: Replacement Skidtube with Wearpads, Fits LH or RH
Start Date: 9/1/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/23/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Wing Walk as per dwg QSI005 4.4 Batch <u>M135510</u>	0.00							
250									
HandFinish	Memo	0.00							
Hand Finishing									
251	QC3- Inspect Part Finish	0.00							
251									
QC	Memo	0.00							
Quality Control									
									DAS 38 9-89 OCT 24 2016
260	Identify as per dwg & Stock Location: <u>w/o</u>	0.00							
260									
Packaging	Memo	0.00							
Packaging									
									<u>16/11/10</u> <u>EP</u>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 148123

Friday, June 24, 2016 2:05:37 PM

148123

Page 12

Item ID: D119-646-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 15-560 Stop ***NS2***
Item Name: Replacement Skidtube with Wearpads, Fits LH or RH
Start Date: 9/1/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/23/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	QC21- Final Inspection - Work Order Release	0.00							
270									
QC	Memo	0.00							
Quality Control									

16/11/10 
DAS
21
9-59
NOV 10 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Friday, June 24, 2016 2:05:37 PM

148123

D119-646-041

Required Date: 9/23/2016

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC IPP rev B
10.02.22 per PAR 09-043 EC verified by:DD IPP REVC 12.11.05
(DEOD3887-B-1)(ecn 12-675) DD verf:JLM IPP REV:D 13.03.20 per
chg003 ECN13-534 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-1-190		Manufactured	No			110	Each	30.0000	1	1			
D2500-1-190 Ext'n -1' Beam Tube 4"													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG002	145247	30				1			
					140538	30							
D2579		Manufactured	No			140	Each	177.0000	2	2			
D2579 Crossbolt Spacer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG001	123997	177							
					141711	1				2			
						176							
D2855-3		Manufactured	No			240	Each	1.0000	2	2			
D2855-3 Cap													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP001		1							
					137525	1		B142564		x2			

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Page 2

Work Order ID: 148123

148123

Parent Item: D119-646-041

D119-646-041

Parent Item Name: Replacement Skidtube with Wearpads, Fits LH or RH

Start Date: 9/1/2016

Required Date: 9/23/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1611-005

Purchased

No

240

Each

407.0000

16

16

NAS1611-005

O-RING

16/10/18

Location

Loc Qty

Loc Code

FP001

407

11135465

x16

m129198

11

m133498

196

m134816

200

D3492-5

Manufactured

No

240

Each

196.0000

16

16

D3492-5

Plug

16/10/18

Location

Loc Qty

Loc Code

FP001

196

B145446

x16

133396

8

136396

6

138198

2

142818

180

D3672-1

Manufactured

No

240

Each

1,016.000

2

2

D3672-1

Washer, Phenolic

16/10/18

Location

Loc Qty

Loc Code

FG

10

85222

10

FP001

14

112218

14

ST049

492

134785

492

x2

ST051A

500

147077

500

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Page 2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 3

Work Order ID: 148123

148123

Parent Item: D119-646-041

D119-646-041

Parent Item Name: Replacement Skidtube with Wearpads, Fits LH or RH

Start Date: 9/1/2016

Required Date: 9/23/2016

Start Qty: 1.00

Required Qty: 1.00

D3681-1 Manufactured No

160 Each 70.0000 8 8

D3681-1

Spacer

**

Location

Loc Qty

Loc Code

LG001

70

142904

70

D3847-1 Manufactured No

240 Each 51.0000 5 5

D3847-1

Wearpad

**

Location

Loc Qty

Loc Code

FP001

51

138338

10

142745

25

142854

2

146614

14

D3847-11 Manufactured No

240 Each 38.0000 1 1

D3847-11

Wearpad

**

Location

Loc Qty

Loc Code

FP001

38

138418

1

142783

24

146945

13

D3885-1 Manufactured No

140 Each 19.0000 1 1

D3885-1

Standard Web

**

Location

Loc Qty

Loc Code

LG002

19

142573

19

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Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER :							

Picklist Print

Friday, June 24, 2016 2:05:37 PM

Page 4

Work Order ID: 148123

148123

Parent Item: D119-646-041

D119-646-041

Parent Item Name: Replacement Skidtube with Wearpads, Fits LH or RH

Start Date: 9/1/2016

Required Date: 9/23/2016

Start Qty: 1.00

Required Qty: 1.00

D3903-1 Manufactured No 160 Each 213.0000 12 12

D3903-1

Spacer

**

BE/6-09-29
B 148673 x 9
B 150281 x 3

Location

Loc Qty

Loc Code

LG001

213

142730

213

ALS4-1032-130 AE4LS4-1032-130 Purchased No 220 Each 3,138.000 30 30

ALS4-1032-130

Rivnut

**

all 16/10/18

Location

Loc Qty

Loc Code

CCK005

1596

M134502

1596

M135442

x30

FP001

552

M133077

122

M134502

430

ST556

990

M134502

990

AN3C5A Purchased No 240 Each 1,188.000 32 32

AN3C5A

Bolt

**

all 16/10/18

Location

Loc Qty

Loc Code

FG

5

122800

5

FP001

488

M134502

488

M135297

x32

OVER002

300

M134955

300

ST350

395

M133234

1

M134676

394

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Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

Picklist Print

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Page 5

Work Order ID: 148123

148123

Parent Item: D119-646-041

D119-646-041

Parent Item Name: Replacement Skidtube with Wearpads, Fits LH or RH

Start Date: 9/1/2016

Required Date: 9/23/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

Each

5,760.000

32

NAS1149C0332R******

WASHER

*del 16/10/16*LocationLoc QtyLoc Code

FP001

1758

*M135274**X32*

m132930

1004

m134073

128

m134962

626

GA

141

m133284

141

ST266

3861

m134736

1861

m135046

2000

MS24694-C52

Purchased

No

Each

69.0000

2

MS24694-C52******

SCREW

*del 16/10/16*LocationLoc QtyLoc Code

FP001

63

*M135466**X2*

m127059

17

m133855

46

ST287

6

124308

6

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Page 5

DQA: _____ Date: _____

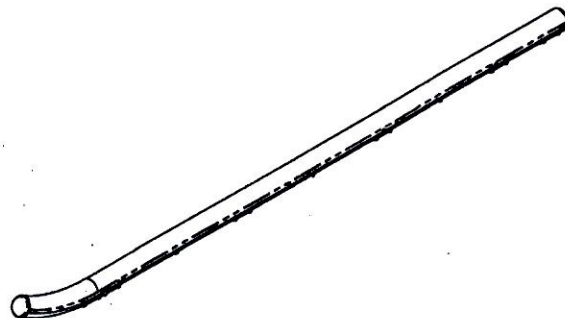
WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition				
					Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐						



D3887-041 STANDARD SKIDTUBE ASSY WITH WEARPAD (SHOWN)
D3887-043 STANDARD SKIDTUBE ASSY WITH WEAPLATE (SIMILAR)
D3887-045 STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3885-1 WEB
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3887-041 = 32.0 lbs
 D3887-043 = 37.0 lbs
 D3887-045 = 38.1 lbs
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
 THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) INSERT D3885-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP
- 11) INSERT D3492-045 PLUG ASSY INTO Ø0.197 HOLES (BOTH SIDES OF TUBE)
- 12) USE DART DRILL TEMPLATE DT8931 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARPLATE INSERTS. INSTALL AELS-1032-130 INTO D3887-11 ONLY. INSTALL AN3C5A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/291.

ITEM	QTY -041	QTY -043	QTY -045	P/N	DESCRIPTION
1	X			D3887-041	STD SKIDTUBE ASSY WITH WEARPAD
2		X		D3887-043	STD SKIDTUBE ASSY WITH WEARPLATE
3			X	D3887-045	STD SKIDTUBE ASSY WITH TRAINING WEARPLATE
10	2	2	2	D2579	CROSS BOLT SPACER
11	2	2	2	D2865-3	CAP
12	16	16		D3492-045	PLUG ASSY
13	2	2	2	D3672-1	PHENOLIC WASHER
14	8	8	8	D3681-1	SPACER
17	5	5		D3847-1	WEARPAD
18	1	1		D3847-11	AFT WEARPAD
19		1		D3847-043	FWD WEARPLATE ASSY
20		1		D3847-045	CENTER WEARPLATE ASSY
21		1		D3847-047	AFT WEARPLATE ASSY
22			1	D3849-041	FWD TRAINING WEARPLATE ASSY
23			1	D3849-043	AFT WEARPLATE ASSY
24	1	1	1	D3885-1	STANDARD WEB
25	1	1		D3887-11	STANDARD SKIDTUBE
26			1	D3887-13	STANDARD SKIDTUBE
27	12	12	12	D3903-1	SPACER
28			16	D3904-1	WASHER
41	30	30		AL84-1032-130	INSERT
42	32	32	2	AN3C5A	BOLT
43			8	AN3C48A	BOLT
44	32	32		NAS1149C0332R	WASHER (OR AN980C10L)
45			8	MS21043-3	NUT
46	2	2	2	MS24894-C52	SCREW

RELEASED

UNDER REVIEW

15.04.30 URF15-560 AP

2014 NOV 24 *up*

ECN 14-638

D	REVISED BEND TOLERANCES FOR MANUFACTURABILITY, 136.07 WAS 134.04 (ZN D5-8), ADD 5.07 (ZN C2-8), ADD 116.8 (ZN D5-8), DELETE GASKETS (BOM, SH 2)	DB	13.09.20
C	(SH 1, PL 2, ZN C2-2, C3-2, C4-2) ITEM 13, QTY 2 WAS 4, ITEM 42, QTY 32 WAS 34, ITEM 44, QTY 30 WAS 32, ADD ITEM 46, MS24894-C52 WAS AN3C5A, 2 PLCS (ZN C1-5, C1-6, B4-7) 0.201 CSK 90.385 X 100 WAS 90.214 THRU, ADDED DETAIL F (ZN C4-5, C5-8, B8-7), ADD ITEM 10, D2579 CROSS BOLT SPACER (ZN D4-1, A8-7)	DB	13.02.19
B	AL84-1032-130 WAS AELS-1032-130 (ZN C4-1, C5-7, C3-7); ADD DT8931 (ZN A8-1), ADD 134.04 (ZN C4-8), D2865-3 WAS D2579 (ZN D4-1, C7-2, C2-2, C7-3, C2-3, C7-4, C2-4); AN3C5A WAS AN3C4A (ZN C6-2, C2-2, C6-3, C2-3, C6-4, C2-4); Ø0.313 WAS Ø0.328 (ZN C4-5, C4-5, C2-7 & B3-7)	RF	09.08.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3887	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		A119 STD SKIDTUBE ASSY	NTS
DATE	13.09.20	COPYRIGHT © 2000 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS NOT TO BE RELEASED OR DISCLOSED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

w/o 148123

dem 16/06/24

AN3C5A BOLT
D3672-1 PHENOLIC WASHER
NAS1149C0332R WASHER
(1 PER SIDE)

SEAL WITH
SIKAFLEX-241/291

D2855-3 CAP

D3847-11
WEARPAD

1.5
1.5
1.5
2.00 DISTANCE TO D3885-1 WEB, REF

BLACK ANTI-SKID TO 0.5
ABOVE LOCATION RIDGE
TYP

11
Ø0.187
8 PL PER SIDE
REF

AN3C5A BOLT
NAS1149C0332R WASHER
24 PL

PLUG UNUSED INSERTS WITH
AN3C5A BOLT
NAS1149C0332R WASHER
8 PL

D3847-1
WEARPAD
5 PL

D2855-3 CAP

SEAL WITH
SIKAFLEX-241/291

MS24894-C52 SCREW
(1 PER SIDE)

D3887-041 STANDARD SKIDTUBE ASSY WITH WEARPAD
(MAKE FROM D3887-11)

UNDER REVIEW

15.04.30 URF15-560 AP

RELEASED

2014 NOV 24 *q*

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3887	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		A119 STD SKIDTUBE ASSY	NTS
DATE	13.09.20	COPYRIGHT © 2000 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

AN3C5A BOLT
D3872-1 PHENOLIC WASHER
NAS1149C0332R WASHER
(1 PER SIDE)

SEAL WITH
SIKAFLEX-241/291

D2855-3 CAP

D3847-11
WEARPAD

D3847-047
AFT WEARPLATE ASSY

AN3C5A BOLT
NAS1149C0332R WASHER
30 PL

D3847-045
CENTER WEARPLATE ASSY

D3847-043
FWD WEARPLATE ASSY

D3847-1
WEARPAD
5 PL

BLACK ANTI-SKID TO 0.5
ABOVE LOCATION RIDGE
TYP

11
Ø0.197
8 PL PER SIDE
REF

2.00 DISTANCE TO D3885-1 WEB, REF

1.5

D2855-3 CAP

SEAL WITH
SIKAFLEX-241/291

MS24694-C52 SCREW
(1 PER SIDE)

D3887-043 STANDARD SKIDTUBE ASSY WITH WEARPLATE
(MAKE FROM D3887-11)

UNDER REVIEW

15.04.30 URF15-560 AP

RELEASED

2014 NOV 24 *ap*

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3887	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		A119 STD SKIDTUBE ASSY	NTS
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AN3C5A BOLT
D3672-1 PHENOLIC WASHER
NAS1149C0332R WASHER
(1 PER SIDE)

SEAL WITH
SIKAFLEX-241/291

D2855-3 CAP

AN3C46A BOLT
D3904-1 WASHER, 2 PL
MS21043-3 NUT
8 PL

BLACK ANTI-SKID TO 0.5
ABOVE LOCATION RIDGE
TYP

1.5 1.5

2.00 DISTANCE TO D3885-1 WEB

D3849-043
AFT TRAINING WEARPLATE ASSY

D3849-041
FWD TRAINING WEARPLATE ASSY

1.5 D2855-3 CAP

SEAL WITH
SIKAFLEX-241/291

MS24884-C52 SCREW
(1 PER SIDE)

UNDER REVIEW

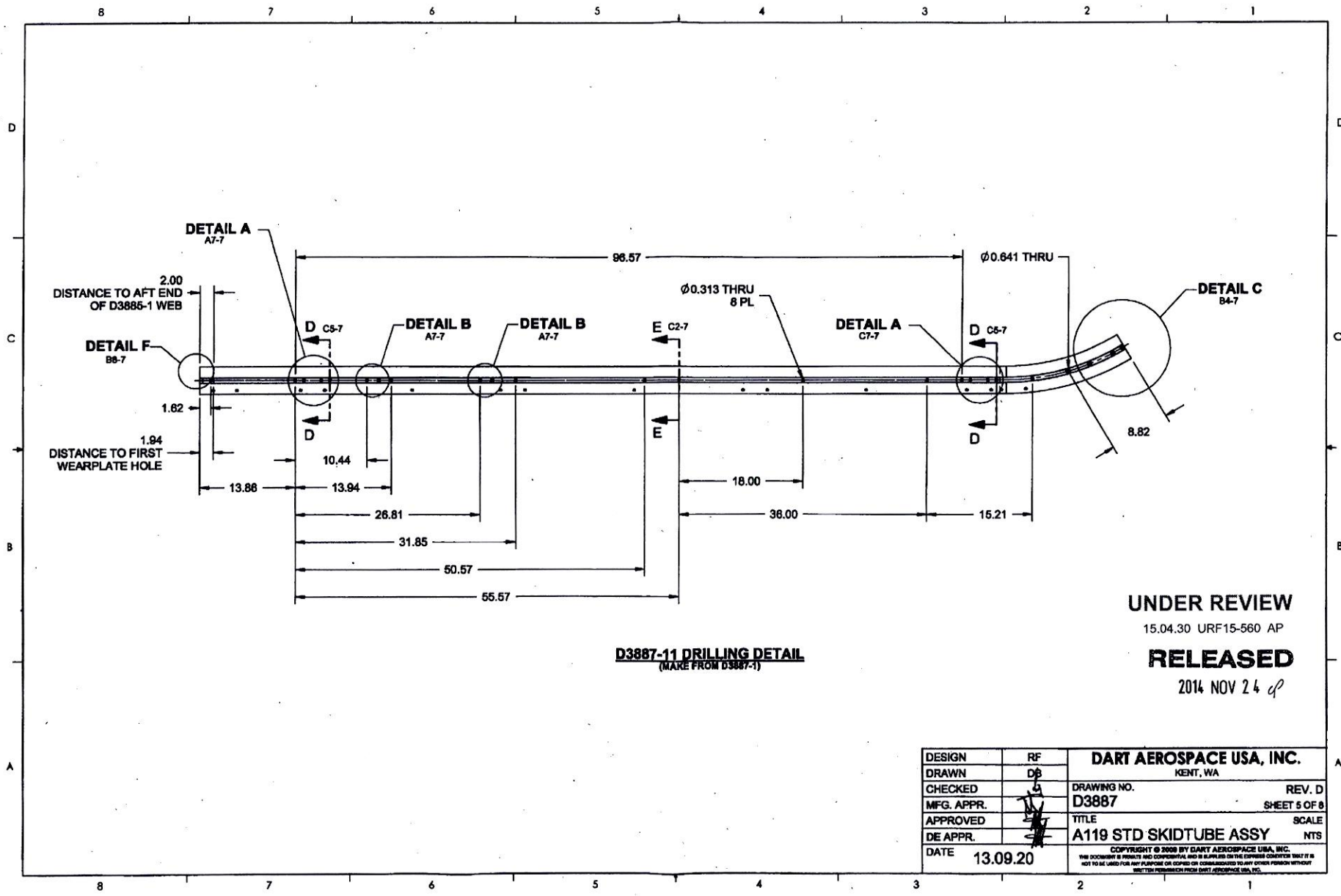
15.04.30 URF15-560 AP

RELEASED

2014 NOV 24 *dp*

D3887-045 STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE
(MAKE FROM D3387-13)

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	A	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3887	SHEET 4 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	A119 STD SKIDTUBE ASSY	NTS
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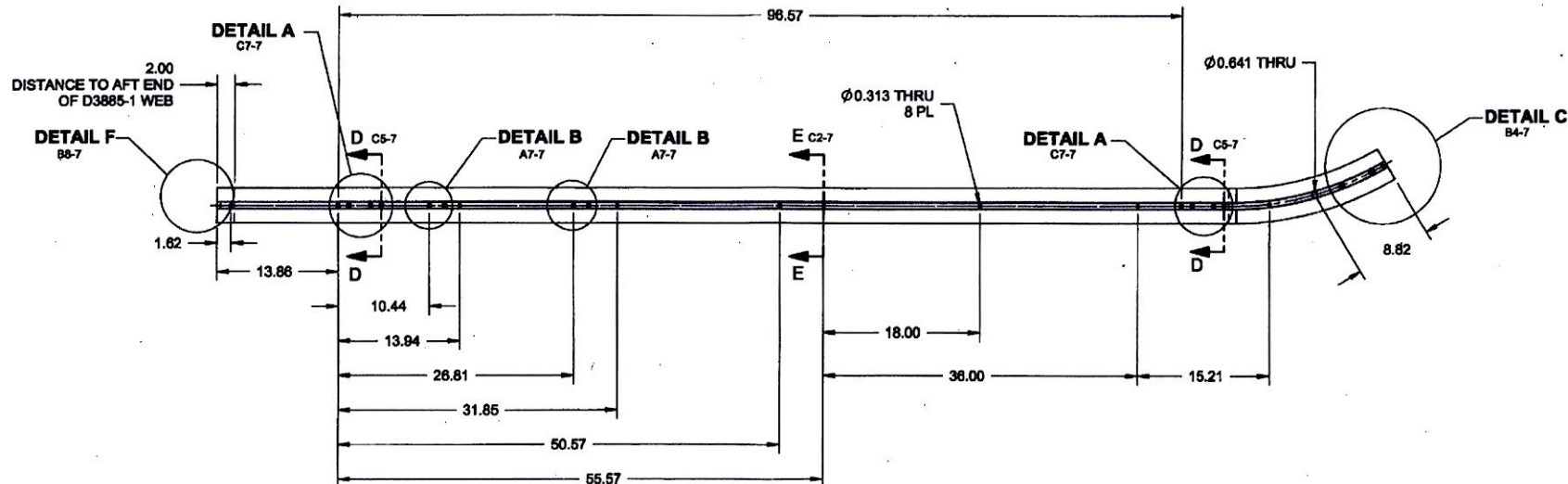
UNDER REVIEW

15.04.30 URF15-560 AP

RELEASED

2014 NOV 24 *ap*

DESIGN	RF	DART AEROSPACE USA, INC.	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3887	SHEET 5 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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D3887-13 DRILLING DETAIL
(MAKE FROM D3887-1)

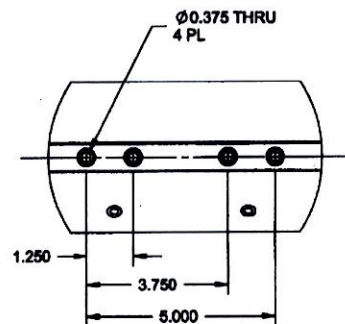
UNDER REVIEW

15.04.30 URF15-560 AP

RELEASED

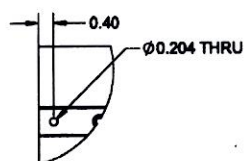
2014 NOV 24 *ap*

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3887	SHEET 8 OF 8
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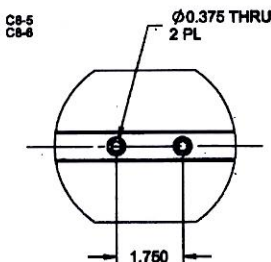


DETAIL A
SCALE 4X

D7-5
C3-5
D7-6
C3-6

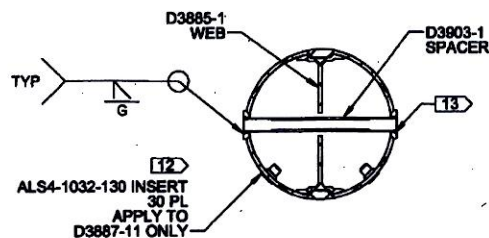


DETAIL F
SCALE 4X



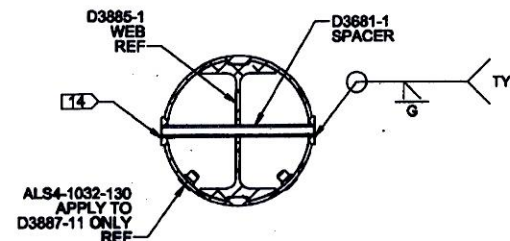
DETAIL B
SCALE 4X

C8-5
C5-5
C8-6
C5-6



SECTION D-D
SCALE 4X
(FOR 12 X $\phi 0.375$ HOLES
PER SKIDTUBE)

C7-5
C3-5
C7-6
C2-6



SECTION E-E
SCALE 4X
(FOR 8 X $\phi 0.313$ HOLES
PER SKIDTUBE)

C4-5
C4-6

NOTES:

13) AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.375$ HOLES ONLY:

- CHAMFER HOLES $\phi 0.475 \times 45^\circ$
- INSERT D3903-1 SPACER
- WELD INTO PLACE AND GRIND FLUSH
- CBORE TO 0.313×0.75 DEEP
- DEBURR HOLES

14) AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.313$ HOLES ONLY:

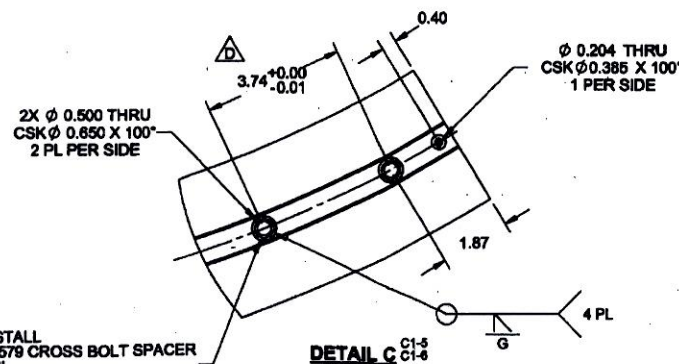
- CHAMFER HOLES $\phi 0.354 \times 45^\circ$ OR 0.050 DEEP $\times 45^\circ$ (BOTH SIDES)
- INSERT D3681-1 SPACER
- WELD INTO PLACE AND GRIND FLUSH
- DEBURR HOLES

UNDER REVIEW

15.04.30 URF15-560 AP

RELEASED

2014 NOV 24

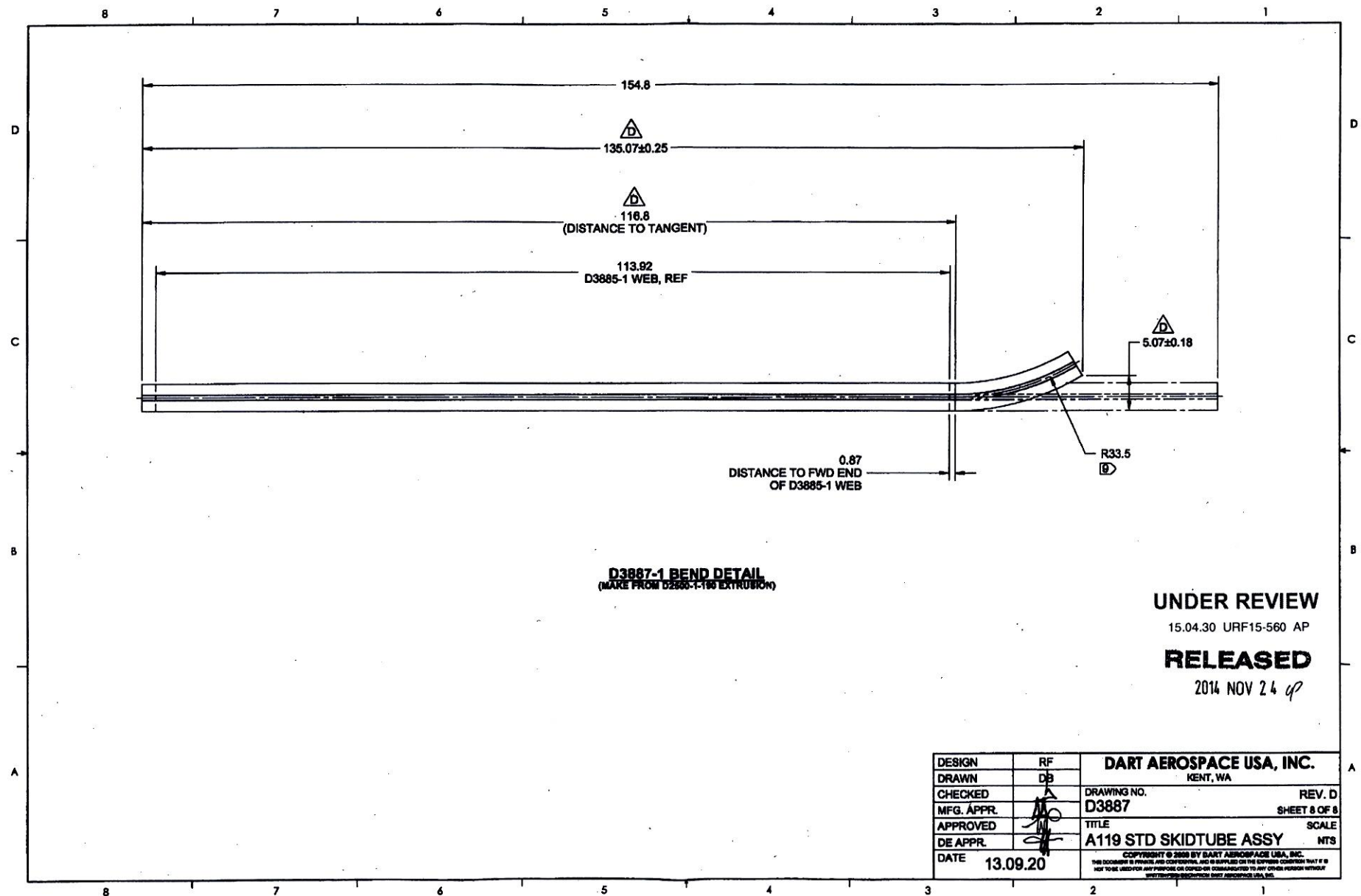


DETAIL C
SCALE 4X

C1-5
C1-6

INSTALL
D2579 CROSS BOLT SPACER
2 PL

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3887	SHEET 7 OF 8
APPROVED		TITLE	SCALE
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☒

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☒ Quality ☐ Other ☐					
Date : 16/5/16		Step #: 200		QTY Effective :			MRB (QSI042) Approval DAS 12 9-89 16/7/17		
Description Work Order Deviation				Disposition				Completed By	
No powder coat on saddle region per customer request.				Acceptable per attached masking instructions				16-10-17 DAS 34 9-89	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				☒ OTHER : Customer			

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☒

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☒ Quality ☐ Other ☐					
Date : 16/3/16		Step #: 240		QTY Effective :		MRB (QSI042) Approval DAS 12 16/7/16 9.80			
Description Work Order Deviation				Disposition					
Plug unused holes with AN3C4A Bolts rather than AN3CSA Bolts.				Acceptable AN3C-4A / 1135058 (x6)					
				Completed By jlp DAS 15 16/10/16 9.80 Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :					
Misidentified ☐	Past Due ☐						

